

Date: Tuesday, 28/11/2006 11:21:35 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 SKIDTUBE "I" BEAM
Job Number	: 29724	Part Number	: D2596
Estimate Number	: 10346	Drawing Number	: D2596 REV C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 28/11/2006	Drawing Revision	: C
Prsh Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 05/12/2006
Previous Run	: 29723	Qty:	12
Written By	: W	Um:	Each
Checked & Approved By			
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D25003100	Ext'n -'I' Beam Web 4"
		 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) Extrusion "I" Beam Web 4" Pick; Qty Part Number Description Batch 1 D2500-3-100 Extrusion B25751 /m-h 06/11/29 ②
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
		 
		Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.625" diameter using a uni-bit 4- Deburr
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		 
		Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1
4.0	QC5	INSPECT WORK TO CURRENT STEP
		 
		Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/12/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L.G

*pm
m-h*

06/12/05



(12)
06/12/05

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



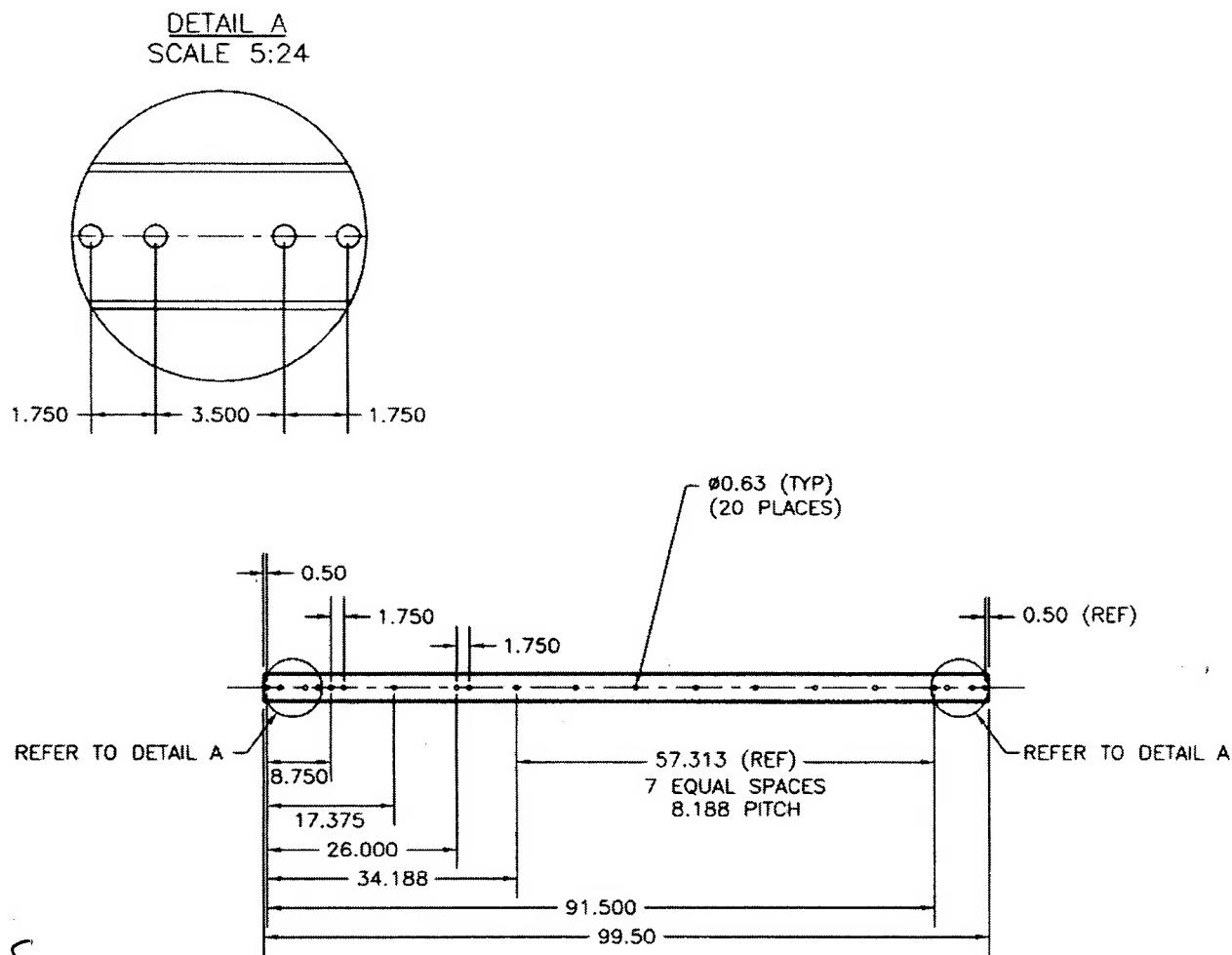
in 06/12/05

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NOTE: Date & initial all entries



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
18/09/17 DS

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE		DRAWING NO.	REV. C
98.09.14		D2596	SHEET 1 OF 1
A	96.09.16	205 WEB	SCALE
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	1:24
C	98.09.14	INCORPORATED DEO 9097	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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